

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005365**Date Inspected:** 23-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

CWI: Mr. Sun Bo

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Paul Dawson arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

This QA Inspector observed ZPMC welder Mr. Song Yun Shu, stencil 059421 is using flux cored welding procedure WPS B-T-2232-TC-U5F to make repairs to OBG deck plate DP570-001-015 R1. Prior to welding the QA Inspector observed the base material had previously been preheated using electrical heater elements. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Zheng Mingye, stencil 066695 is using flux cored welding procedure WPS B-T-2232-TC-U5F to make repairs to OBG deck plate DP570-001-017 R1. Prior to welding the QA Inspector observed the base material had previously been preheated using electrical heater elements. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

The QA Inspector observed ZPMC welder Mr. Shi Yunli stencil 59409 is using welding procedure specification WPS-B-T-2342-U2 (U-rib) to make flux cored tack welds on OBG closed rib test plates. The QA Inspector observed ZPMC is using a torch to preheat the base material prior to commencing each of the tack welds. Items observed by the QA Inspector appear to comply with project specifications.

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QA Inspector observed ZPMC welder Ms. Jiang Maofang, stencil 201250 is using welding procedure specification WPS-B-T-2233-B-U2-F to make flux cored closed rib splice weld DP275-001-120. Prior to welding the QA Inspector observed the groove area where Ms. Jiang Maofang was preparing to weld appears to have been preheated with a torch and the weld joint has been cleaned to bright metal and fit together as specified by the welding procedure specification. Items observed by the QA Inspector appear to comply with project specifications.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
